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Mazdoor Kisan Shakti Sangathan

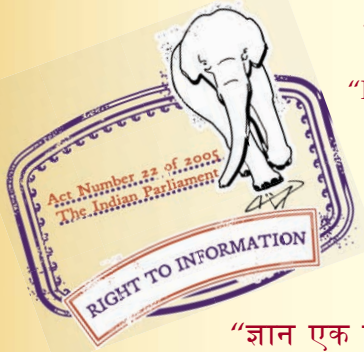
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“Step Out From the Old to the New”

IS 11193 (1984): Jute Canvas Postal Bags [TXD 3: Jute and Jute Products]



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“Knowledge is such a treasure which cannot be stolen”

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IS : 11193 - 1984

Indian Standard

SPECIFICATION FOR
JUTE CANVAS POSTAL BAGS

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INDIAN STANDARDS INSTITUTION
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

Indian Standard

SPECIFICATION FOR JUTE CANVAS POSTAL BAGS

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Indian Standard

SPECIFICATION FOR JUTE CANVAS POSTAL BAGS

0. FOREWORD

0.1 This Indian Standard was adopted by the Indian Standards Institution on 15 December 1984, after the draft finalized by the Jute and Jute Products Sectional Committee had been approved by the Textile Division Council.

0.2 While preparing this standard, assistance has been derived from Specification No. G/Tex/J-22 H Revised 1977 Specification for Jute Canvas Mail Bags (Proofed and Unproofed), formulated by the Directorate General of Supplies & Disposals (DGS&D).

0.3 For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test, shall be rounded off in accordance with IS : 2-1960*. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

1. SCOPE

1.1 This standard prescribes the constructional details and other requirements of four sizes of jute canvas postal bags, proofed and unproofed.

2. MANUFACTURE

2.1 Fabric — The bags shall be made out of jute canvas, proofed or unproofed, conforming to IS : 10036 (Part 2)-1982†.

2.1.1 Cotton Sewing Thread — Cotton sewing thread used for stitching shall be 27 × 9 tex and shall conform to the variety No. 35 of IS : 1720-1978‡. Alternatively, flax threads of 165 × 3 tex having a minimum breaking load of 8 kgf when tested as per IS : 1670-1970§ shall be used.

*Rules for rounding off numerical values (*revised*).

†Specification for jute canvas: Part 2 Fine 660 g/m².

‡Specification for cotton sewing threads (*second revision*).

§Method for determination of breaking load, elongation at break and tenacity of yarns (*first revision*).

2.1.2 Rim Cord — Jute cord of about 22 mm circumference made of 4 strands, each strand of minimum 2 ply, should be used for the rim cord.

2.1.3 Iron Loops — Iron loops of 3.7 ± 0.1 mm dia galvanized iron wire shall be used. The details of the dimensions and the make up shall be as shown in Fig. 1. The ends of the iron loops shall be butt jointed and welded. Lap joints with minimum overlapping of 15 mm and welded at both the cut edges soldered on the entire overlapped portion may also be used. For lap-jointed iron loops, the cut edges shall be properly finished to avoid cutting actions.

2.1.4 Tabs for Fixing Iron Loops — The tabs shall be made from jute canvas proofed/unproofed fabric as has been used for the fabrication of the bags. The tabs shall be made of two folds of canvas length with a turn-in of 15 mm at both sides and having a finished width of 35 mm. The position and the finished length of the tabs at each side of the bags shall be as shown in Fig. 1 and shall be 90 mm, *Min.*

2.1.5 Whip Cord — Whip cord of 5 ply cotton twine 1 000 × 5 d tex conforming to variety No. 26 of IS : 1720-1978* shall be used.

2.2 Construction

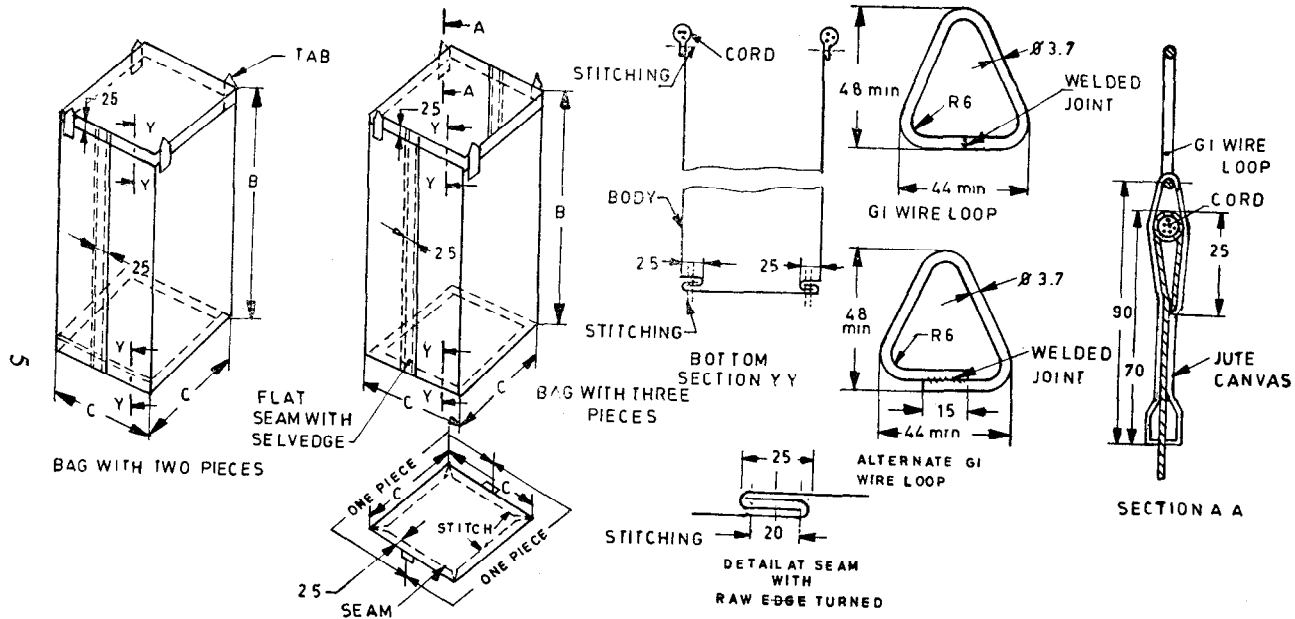
2.2.1 Shape and Construction — The shape and construction of the bags shall be as shown in Fig. 1.

2.2.2 Bags of size No. 1 and 2 shall be made of three pieces of canvas, two for the sides and the other one for the bottom. The bottom piece shall be of square or rectangular shape. The perimeter of the base of bags of both the sizes shall be 172 cm, *Min.* In both the sizes, the length of the bags 'B' (that is, the height), shall be in the warp direction of the fabric.

2.2.3 Bags of sizes No. 3 and 4 shall also be made of two pieces of canvas, one for the sides and the other for the bottom, which shall be of square shape. The perimeter of the base of the fabric of both the sizes shall be 142 cm, *Min.* In both the sizes, the length of the bags, that is, the height 'B' of the bag may be in warp or weft direction of the fabric.

2.2.4 Fixing of Bottom Piece — The bottom piece for all the sizes of bags shall be joined with the sides and the inside of the bags to prevent fraying. The two pieces shall be jointed with two rows of stitches. The first row of stitches shall not be visible from outside the bags after joining. The second row of the stitches shall be put at a distance of not less than 25 mm away from the first row of stitches, over a turn of 13 mm, *Min* of the side pieces. The bottom piece shall remain up to the edge of the turn-in so that the second row of stitches falls over 4 layers of canvas, for example, two layers of bottom piece, one layer of side piece and the turn-in of the side piece. All the four corners of the bottom piece shall be stitched in continuation of the second row of stitches as shown in Fig. 1.

*Specification for cotton sewing threads (*second revision*).



All dimensions in millimetres.

FIG. 1 JUTE CANVAS MAIL BAG

2.2.5 Fixing of Rim Cord — The jute rim cord as specified in 2.1.2 is to be fixed inside the top hemming. It shall be in one length only. The rim cord shall be neatly tied with an overlap of 50 mm of the two ends and whipped properly with cord as specified in 2.1.5 before being placed inside the rim. Alternatively, the ends may be whipped and then stitched with the body of the bag with minimum three rows of stitches.

2.2.6 Fixing of Iron Loops — Four iron loops according to 2.1.3 shall be fixed with tabs. The ends of the tab shall be turned-in to a depth of 13 mm, *Min* and sewn with the sides with the position of the loops opposite to each other as shown in Fig. 1.

2.2.7 Seam — The sides of the postal bags shall be machine stitched with an overlapping of 25 mm, *Min* and with two rows of stitches, approximately 20 mm apart. In case of any raw edge, the same shall be turned to a depth of 13 mm, *Min* and then stitched with an overlapping of 25 mm, *Min*. The stitches should be of uniform tension throughout with all the loose ends securely fastened. The number of stitches per dm shall be not less than 24.

2.2.8 Hemming — The top of the bags shall be hemmed to a depth of 25 mm, *Min* with a turning on the outside of the bag and the raw edge, if any, are to be initially turned into a depth of 13 mm, *Min*. The stitches shall not be less than 3 mm away from the edge of the turning.

2.2.9 Stitches other than Seam — The stitching shall be done by machine. The stitches should be of uniform tension throughout with all the loose ends securely fastened. The number of stitches per dm shall be not less than 24.

3. REQUIREMENTS

3.1 The bags shall conform to the manufacturing particulars given in 2.

3.2 The dimensions and tolerances of the bags shall be as given in Table 1.

TABLE 1 DIMENSIONS AND TOLERANCES OF POSTAL BAGS

(Clauses 2.2.2, 2.2.3, 3.2 and Fig. 1)

| SIZE No. | HEIGHT 'B' | BASE | |
|-------------|------------|---------------|------------|
| | | Length 'C' | Width 'C' |
| | <i>Min</i> | mm | mm |
| (1) | (2) | (3) | (4) |
| 1 | 1 220 | 430 or 385 | 430 480 |
| 2 | 1 070 | 430 or 385 | 430 480 |
| 3 | 810 | 355 | 355 |
| 4 | 710 | 355 | 355 |

Tolerance

± 10 mm

± 10 mm

3.3 The bags should be free from sewing and other fabrication defects.

4. MARKING

4.1 The marking on the bags shall be as required by the buyer and it shall be done neatly by using indelible ink on both the sides of the bags.

4.2 Each bag shall also be marked on the inner side using indelible ink with the manufacturer's name or trade-mark together with the year of manufacture.

4.2.1 Each bag may also be marked with the ISI Certification Mark.

NOTE — The use of the ISI Certification Mark is governed by the provisions of the Indian Standards Institution (Certification Marks) Act and the Rules and Regulations made thereunder. The ISI Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well-defined system of inspection, testing and quality control which is devised and supervised by ISI and operated by the producer. ISI marked products are also continuously checked by ISI for conformity to that standard as a further safeguard. Details of conditions, under which a licence for the use of the ISI Certification Mark may be granted to manufacturers or processors, may be obtained from the Indian Standards Institution.

5. PACKING

5.1 The bags shall be packed as agreed to between the buyer and the seller.

6. SAMPLING

6.1 The quantity of postal bags of same designation delivered to a buyer against a despatch note shall constitute a lot.

6.2 The conformity of the lot shall be determined on the basis of the tests carried out on the samples selected from it.

6.3 Unless otherwise agreed to between the buyer and the seller, the number of bags to be selected from a lot shall be according to col 1 and 2 of Table 2.

TABLE 2 SAMPLE SIZE AND PERMISSIBLE NUMBER OF NON-CONFORMING BAGS

| LOT SIZE | SAMPLE SIZE | PERMISSIBLE NO. OF NON-CONFORMING BAGS |
|-----------------|-------------|--|
| (1) | (2) | (3) |
| Up to 100 | 13 | 1 |
| 101 ,, 150 | 20 | 2 |
| 151 ,, 300 | 32 | 3 |
| 301 ,, 500 | 50 | 5 |
| 501 ,, 1 000 | 80 | 7 |
| 1 001 ,, 3 000 | 125 | 10 |
| 3 001 and above | 200 | 14 |

6.4 The number of bags selected according to **6.3** shall be examined for all the manufacturing details as per **2** and also the requirements as given under **3**.

6.5 Criteria for Conformity— The lot shall be declared as conforming to the requirements of the specification if the following condition is satisfied:

The number of bags found not in conformity with the requirements for anyone or more of the characteristics mentioned in **6.4** is less than or equal to the corresponding number given in col 3 of Table 2.